



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7702
Job Sheet 205007



Part No: 647.7702

Job Qty: 30 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 3/6/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	Large Fab - Welded Assy-1	30 pcs	3/6/20		0.00	12.35	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	MV Feb 24/20
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	K.S / MV
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
							Large Fab - 12	
130	QC 9	30 pcs	3/6/20		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	DAS 24
							QC 9 - 43	9-89
							QC 9 - 50	
							QC 9 - 9	
140	QC 5	30	3/6/20		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	DAS 24
							QC 5 - 24	9-89
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	



Container No: S258859



Part: 647.7702

Job No: 205007

Serial No/Batch: S258859

Revision: Rev A2

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/27/20

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Outsource - 3 - Cadplate	30 pcs	3/6/20		GRO002-VC	7 <i>15</i> 2020-02-28
160	Packaging 2-1 - Receive - B4B	30 pcs	3/6/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	<i>15</i> MAR 13 2020
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
170	QC 6	30 pcs	3/6/20	0.00 0.00	QC 6 - 9	<i>DAS</i> 82 9-89
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	MAR 20 2020
					QC 6 - 81	<i>DAS</i>
180	Spray Paint - 2 - B4B	30 pcs	3/6/20	0.00 2.31	Spray Paint - 1 - B4B	<i>41</i> MAR 23 2020
					Spray Paint - 2 - B4B	<i>3-89</i>
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
190	QC 14	30 pcs	3/6/20	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	

					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	DAS 40 APR 20 2020 9-89
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
200	Packaging 3-1 - Stock - B4B	30 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS 28 9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
210	QC 21 - SA	30 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	DAS 21 APR 22 2020 9-89
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 120 - (Weld per dwg A/R 4130 rod Batch: M12724) 1- ASSEMBLE AND WELD AS PER DWG 0 ***IMPORTANT
 Descriptions: DIMENSION IS 11.60" ***

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O : 45978 Group Altech CAD

PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - INSPECT USING GO/NO GO GAUGE

180 - (Spray Paint / NDT Room) PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER

BATCH: 5236137

190 - (QC14- Inspect Spray Paint)

200 - (Identify as per dwg & Stock Location:_____)

210 - (QC21- Final Inspection - Work Order Release) PLEASE NOTE ON PO: Apply only Class 3 Cad to the threaded are only CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7711	Strut Tube	30 pcs (1 ea)	120-Large Fab - Welded Assy-1	5251900
647.7712	Strut Tube	30 pcs (1 ea)	120-Large Fab - Welded Assy-1	5256207
647.7713	Strut Thread	30 pcs (1 ea)	120-Large Fab - Welded Assy-1	5256860

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7711	30	4	0
	647.7712	30	19	0
	647.7713	30	12	0

Part Specifications

Specifications could not be found.

Plex 12/23/19 2:44 PM Dart.lajeunesse.marie

M# 019696

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045978



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045978

PO Date: 2/28/20

Due Date: 3/9/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-03-02

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205006	647.7701	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC 33 - NO baking required note: cad plate should not be too thick around tread	Firmed X30	-	3/9/20	30 pcs	0 pcs	30 pcs	\$14.16/pcs	\$424.80
	205084				Firmed X11	-	3/9/20	11 pcs	0 pcs	11 pcs	\$14.16/pcs	\$155.76
								Sub Total:	41	0	41	\$580.56

MAR 10 2020

MAR 10 2020

2	205085	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC33 - NO baking required note: cad plate should not be too thick around tread	Firmed X10	-	3/9/20	10 pcs	0 pcs	10 pcs	\$16.37/pcs	\$163.70
	205007				Firmed X30	-	3/9/20	30 pcs	0 pcs	30 pcs	\$16.37/pcs	\$491.10
								Sub Total:	40	0	40	\$654.80

MAR 10 2020

MAR 13 2020

Plex 3/2/20 11:25 AM Dart.Guerin.Kimberley



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045978



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	206309	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC33 - NO baking required ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed X10	-	3/9/20	10 pcs	0 pcs MAR 10 2020	10 pcs	\$12.72/pcs	\$127.20
	206282				Firmed X10	-	3/9/20	10 pcs	0 pcs MAR 10 2020	10 pcs	\$12.72/pcs	\$127.20
Sub Total:								20	0	20		\$254.40
Grand Total:											\$1,489.76	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guérin

Plex 3/2/20 11:25 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(026741-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

026741 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
10-Mar-2020		Jigar Patel				POHB045978				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Quantités / Quantities Comm. /Ordered Exp/ Shipped Qté NC/ NC Qty Qté Scrap/ À venir / Back Order				
4	647.7702 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD			CADMIUM CH	30	30	0	0	0

DAS
82
9-89

RECEIVED
MAR 12 2020
DART AEROSPACE LTD.

DAS
82
9-89

RECEIVED
 MAR 12 2020
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Guillaume Gamache-Beauchamp

From: Patrick Duval
Sent: 16 mars 2020 15:08
To: Guillaume Gamache-Beauchamp
Subject: FW: Guillaume QC6

FYI

Pat Duval

From: Patrick Duval
Sent: March 16, 2020 2:15 PM
To: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>; 'Marie Lajeunesse (mlajeunesse@dartaero.com)' <mlajeunesse@dartaero.com>; Zoe Evans (zevans@dartaero.com) <zevans@dartaero.com>; 'Shannon Hadley (shadley@dartaero.com)' <shadley@dartaero.com>
Cc: Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Serge Carriere (scarriere@dartaero.com) <scarriere@dartaero.com>; Valerie Miller <vmiller@dartaero.com>
Subject: Guillaume QC6

All
I have received & reviewed the training from Guillaume Gamache-Beauchamp regarding his inspection levels for QC6 and he is competent to perform this inspection levels.

Zoe,
Please adjust his training recorded to show that he has completed his training. (Stamp 82)

Shannon,
Please add the appropriate work center

Pat Duval
QC Coordinator

DART AEROSPACE
T: 1-613-632-5200 ext.228
www.dartaero.com
pduval@dartaero.com

